

Work Order ID 132885

Thursday, May 14, 2015 8:30:21 AM

132885

Page 1

Item ID: D4050-3 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Strut
 Start Date: 5/14/2015 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 5/22/2015 Req'd Qty: 1.00 ***1*** Customer:
 Reference: REWORK

Approvals: Process Plan: unc Date: 5-5-14 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4050	B								

180

180

HandFinish
Hand Finishing

Memo
PULL FROM STOCK D4050-3 X 1 B101971
SCUFF LIGHTLY AND TOUCH UP PAINT

0.00

0.00

190

190

QC
Quality Control

QC5- Inspect part completeness to step on W/O 0.00

Memo 0.00

DAS
6
9-89

P.T.O.

DAS
38
9-89
JUL 23 2015

200

200

Packaging
Packaging

Identify as per dwg & Stock Location: ST357 0.00

Memo 0.00

① JA JUL 24 2015

DQA:

Date:

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed:

Date:

Work Order update only

Work Order: <u>132885</u> Part No. <u>DY050-3</u> NCR No. _____	DISPOSITION		AGAINST DEPARTMENT/PROCESS							
	Rework	☒	Skid-tube	☐	Crosstube	☐	Water Jet	☐	Engineering	☐
	Scrap	☐	Machining	☐	Small Fab	☐	Prod. Eng. Coord.	☐	Quality	☐
	Use-as-is	☐	Thermoforming	☐	Finishing	☐	Rec/Store/Packaging	☐	Other	☐
	Suspected Unapproved	☐	Large Fab	☐	Composite	☐	Supplier	☐		☐

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design				pull from stock D4050-3 B101971 v1	S 15/07/27 azwiz	Scuff lightly and	DAS 41 9-89	DAS 38 9-89 DAS 38 9-89 JUL 23 1989 DAS 38 9-89	DAS 9 9-89 1507-27
Doc/Data						Re powder coat	15-7-15		
Equip/Tooling						Powder coat as per drawing & QSI 5.4.3	① 15-7-22		
Handling/Pre						start time 12:55			
Material						temp. 400°	DAS 34 9-89		
Operator						finish 1:25			
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved						QC 3.			

FAULT CATEGORY

Landing Gear	General		
☐ Bending	☐ Bend	☐ Folio/Program	☐ Outside Dimensions
☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance
☐ Cracks	☐ Broken/Damage/Defect	☐ Hardware	☐ Part Incorrect
☐ Crimp/Kink/Ripple/Wave	☐ Burrs	☐ Inspection Incomplete/Unqualified	☐ Part Lost/Missing
☐ Cuffs	☐ Contamination	☐ Instructions Incomplete/Unclear	☐ Part Moved
☐ Crushing	☐ Countersink	☐ Misaligned/off center	☐ Positioned Wrong
☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Power Loss/Surge
☐ Inspection Strip in Tube	☐ Drawing	☐ Misread	☐ Pressure/Forced
☐ Marks/Chatter	☐ Drill Holes	☐ Off-set	☐ Set-up
☐ Turning Sequence	☐ Finish	☐ Out of Calibration	☐ Temperature/Cure
☐ Wave/Twist in Tube	☐ Fit/Function	☐ Out of Sequence	☐ Weld
			☐ Wrong Stock Pulled
			☐ Other

Work Order ID 132885

132885

Page 2

Thursday, May 14, 2015 8:30:21 AM

Item ID: D4050-3

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Strut

Start Date: 5/14/2015 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 5/22/2015 Req'd Qty: 1.00 *1*

Customer:

Reference: REWORK

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

210

QC21- Final Inspection - Work Order Release

0.00

210

QC

Memo

0.00

Quality Control

20150724 JUL 24 2015
JH
J
MLC
MLC JUL 24 2015

Picklist Print

Page 1

Thursday, May 14, 2015 8:30:20 AM

Work Order ID: 132885

132885

Parent Item: D4050-3

D4050-3

Parent Item Name: Strut

Start Date: 5/14/2015

Required Date: 5/22/2015

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevA: new issue DD 10/01/05 verified by:EC IPP Rev:B as per dwg
revB DD 10.02.18 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4050-3		Manufactured	No				Each	1.0000		1			

D4050-3

Strut

Location

Loc Qty

Loc Code

ST357

1

101971

1

CMF 15-5-14.

List Lots

Wednesday, May 13, 2015 3:48:52 PM

Page 1 of 1

Criteria : Item ID: D4050-3 All Locations All Warehouses All Quantity

Item ID Item Name	Warehouse ID Location ID	Lot Number	Last Trans Date	Lot Qty	Shelf Life Dt Lot Code	Type Code	Comments
----------------------	-----------------------------	------------	-----------------	---------	---------------------------	-----------	----------

D4050-3 Strut	Main Warehouse ST357	101971	2/24/2015	2.0000	QC21		
------------------	-------------------------	--------	-----------	--------	------	--	--

Total: 2.0000

#132885

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐							
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval			
Description Work Order Deviation				Disposition				Completed By			
Root Cause				FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐		No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐		Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐		Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	
OTHER : _____											